

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025210**Date Inspected:** 06-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Liu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:-

OBG Trial Assembly

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Segment 13BE+CE Corner Assembly "I" rib connection plates. The weld designation reviewed is as follows:

OBE13J-001-006,007,008,009,016,017,018,019,037,030,040,041,032,042,043

In process Inspection:-

OBG Trial Assembly

This QA Inspector observed the following work in progress:

SMAW in the 3F position for the OBG Segment 13CE Corner Assembly. The weld joint was designated as: CA3014-049. The welder is identified as #069469. ZPMC QC is identified as Mr. Zhong yong hong. The welding

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

variables recorded by QC appear to comply with WPS-B-P-2113-FCM-1.

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Segment 13BE Vertical panel "I"rib connection plates. The weld joint was designated as: SA3101-001-004. The welder is identified as #051359. ZPMC QC is identified as Mr. Zhong yong hong. The welding variables recorded by QC appear to comply with WPS-B-T-2232-ESAB. Please see the attached picture.

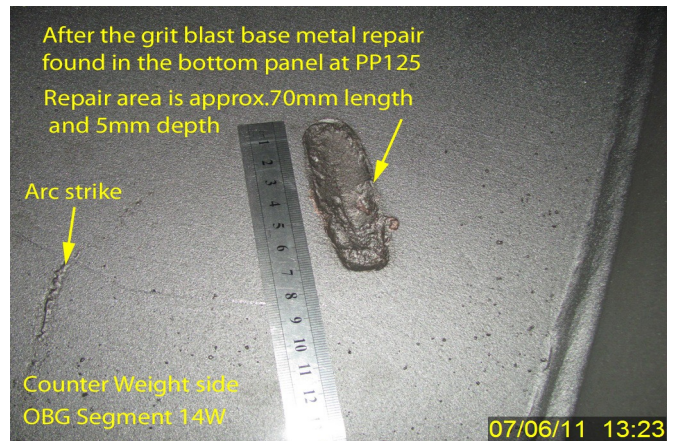
Visual Inspection after Blast

OBG Segment 14W

Counter weight side (PP125 to PP126):-

This QA Inspector performed a preliminary random visual inspection after the grit blast of the Interior components of the Vertical shear plate, Bottom panel stiffeners and Floor Beam of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection. Please see the attached picture.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Pillai,Pandaram

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer